

10 What Is Claimed Is:.

sbB' 1 A method for manufacturing a papermaker's fabric,  
said method comprising the steps of:

providing a laminated structure, said laminated  
structure having a bottom layer and a top layer, said  
5 bottom layer and said top layer each being strips of  
equivalent width and being laminated together, said  
bottom layer being transversely offset with respect to  
said top layer so that an unlaminated portion of said  
bottom layer is along one lateral edge of said  
10 laminated structure and an unlaminated portion of said  
top layer is along the other lateral edge of said  
laminated structure;

spirally winding said laminated structure in a  
plurality of turns wherein said unlaminated portion of  
15 said top layer in one turn of said laminated structure  
overlies said unlaminated portion of said bottom layer  
in an adjacent turn of said laminated structure; and

joining said overlying unlaminated portion of said  
top layer to said unlaminated portion of said bottom  
20 layer to form said papermaker's fabric, said  
papermaker's fabric being in the form of an endless  
loop having an inner surface and an outer surface.

2. A method as claimed in claim 1 wherein said step  
of joining is performed by sewing.

3. A method as claimed in claim 1 wherein said step  
of joining is performed by stitching.

4. A method as claimed in claim 1 wherein said step  
of joining is performed by gluing.

5. A method as claimed in claim 1 wherein said step of joining is performed by melting.

6. A method as claimed in claim 1 wherein said step of joining is performed by welding.

7. A method as claimed in claim 1 wherein said step of providing a laminated structure comprises the steps of:

4 providing <sup>the</sup> a bottom layer, said bottom layer being a base for said laminated structure.

6 providing <sup>the</sup> a top layer, said top layer being adapted to support a paper web in a paper machine; forming a sandwich of said top and bottom layers, said bottom layer being transversely offset with respect to said top layer; and

attaching said top and bottom layers together to form said laminated structure.

8. A method as claimed in claim 7 wherein said step of attaching is performed by sewing.

9. A method as claimed in claim 7 wherein said step of attaching is performed by needling.

10. A method as claimed in claim 7 wherein said step of attaching is performed by gluing.

11. A method as claimed in claim 7 wherein said step of attaching is performed by fusing.

12. A method as claimed in claim 7 wherein said step of attaching is performed by melting.

13. A method as claimed in claim 1 further comprising the step of attaching at least one additional layer of staple fiber material to said papermaker's fabric.

14. A method as claimed in claim 13 wherein said attaching step is carried out on said inner surface of said papermaker's fabric.

15. A method as claimed in claim 13 wherein said attaching step is carried out on said outer surface of said papermaker's fabric.

16. A method as claimed in claim 13 wherein said at least one additional layer of staple fiber material is in the form of a strip spiralled onto one of said inner and outer surfaces of said papermaker's fabric.

17. A method as claimed in claim 13 wherein said at least one additional layer of staple fiber material is applied full-width onto one of said inner and outer surfaces of said papermaker's fabric.

18. A method as claimed in claim 1 further comprising the step of providing a base fabric for said papermaker's fabric, said base fabric being in the form of an endless loop, said endless loop having an inner surface, an outer surface, a first and a second lateral edge, and a fabric width measured transversely between said lateral edges, wherein said laminated structure is spirally wound in a plurality of turns upon said outer surface of said base fabric.

19. A method as claimed in claim 1 further comprising the steps of:

22

providing a base fabric for said papermaker's fabric, said base fabric being in the form of an endless loop, said endless loop having an inner surface, an outer surface, a first and a second lateral edge, and a fabric width measured transversely between said lateral edges; and

slipping said base fabric inside said papermaker's fabric.

20. A method as claimed in claim 1, wherein said laminated structure is a first laminated structure, further comprising the steps of:

providing a second laminated structure, said second laminated structure also having a bottom layer and a top layer, said bottom layer and said top layer each being strips of equivalent width and being laminated together, said bottom layer being transversely offset with respect to said top layer so that an unlaminated portion of said bottom layer is along one lateral edge of said second laminated structure and an unlaminated portion of said top layer is along the other lateral edge of said second laminated structure;

spirally winding said second laminated structure in a plurality of turns upon said papermaker's fabric, wherein said unlaminated portion of said top layer in one turn of said second laminated structure overlies said unlaminated portion of said bottom layer in an adjacent turn of said second laminated structure; and

joining said overlying unlaminated portion of said top layer to said unlaminated portion of said bottom layer.

21. A method as claimed in claim 20 wherein said second laminated structure is spirally wound in a direction opposite to that in which said first laminated structure is wound.

36B2 22. A papermaker's fabric for a paper machine, said papermaker's fabric comprising:

5 a laminated structure, said laminated structure having a bottom layer and a top layer, said bottom layer and said top layer each being strips of equivalent width and being laminated together, said bottom layer being transversely offset with respect to said top layer, so that an unlaminated portion of said bottom layer is along one lateral edge of said  
10 laminated structure and an unlaminated portion of said top layer is along the other lateral edge of said laminated structure; said laminated structure being spirally wound in a plurality of turns wherein said unlaminated portion of said top layer in one turn of  
15 said laminated structure overlies said unlaminated portion of said bottom layer in an adjacent turn of said laminated structure; said overlying unlaminated portion of said top layer being joined to said unlaminated portion of said bottom layer.

23. A papermaker's fabric as claimed in claim 22 further comprising at least one additional layer of staple fiber material attached to one of the inner and outer surfaces of said papermaker's fabric.

24. A papermaker's fabric as claimed in claim 23 wherein said at least one additional layer of staple fiber material is in the form of a strip spiralled onto

one of said inner and outer surfaces of said  
5 papermaker's fabric.

25. A papermaker's fabric as claimed in claim 23  
wherein said at least one additional layer of staple  
fiber material is applied full-width onto one of said  
inner and outer surfaces of said papermaker's fabric.

26. A papermaker's fabric as claimed in claim 22  
further comprising a base fabric in the form of an  
endless loop, said endless loop having an inner surface  
and an outer surface, wherein said laminated structure  
5 is spirally wound upon said outer surface of said base  
fabric.

27. A papermaker's fabric as claimed in claim 22  
further comprising a base fabric in the form of an  
endless loop, said endless loop having an inner surface  
and an outer surface, wherein said base fabric is inside  
5 said papermaker's fabric.

28. A papermaker's fabric as claimed in claim 22  
wherein said laminated structure is a first laminated  
structure and further comprising a second laminated  
structure, said second laminated structure also having  
5 a bottom layer and a top layer, said bottom layer and  
said top layer each being strips of equivalent width  
and being laminated together, said bottom layer being  
transversely offset with respect to said top layer, so  
that an unlaminated portion of said bottom layer is  
10 along one lateral edge of said second laminated  
structure and an unlaminated portion of said top layer  
is along the other lateral edge of said second  
laminated structure; said second laminated structure

being spirally wound in a plurality of turns upon said  
15 papermaker's fabric wherein said unlaminated portion of  
said top layer in one turn of said second laminated  
structure overlies said unlaminated portion of said  
bottom layer in an adjacent turn of said second  
laminated structure; said overlying unlaminated portion  
20 of said top layer being joined to said unlaminated  
portion of said bottom layer.

29. A papermaker's fabric as claimed in claim 22  
wherein said top layer of said laminated structure  
comprises one of the materials selected from the group  
consisting of: staple fiber material; fabric woven from  
5 fibers or filaments; spun-bond, hydroentangled and  
melt-blown nonwoven fabrics; and apertured extruded  
polymeric films.

30. A papermaker's fabric as claimed in claim 22  
wherein said top layer of said laminated structure  
comprises at least two distinct sublayers, each of said  
sublayers comprising one of the materials selected from  
5 the group consisting of: staple fiber material; fabric  
woven from fibers or filaments; spun-bond,  
hydroentangled and melt-blown nonwoven fabrics; and  
apertured extruded polymeric films.

31. A papermaker's fabric as claimed in claim 22  
wherein said bottom layer of said laminated structure  
comprises one of the materials selected from the group  
consisting of: staple fiber material; fabric woven from  
5 fibers or filaments; spun-bond, hydroentangled and  
melt-blown nonwoven fabrics; apertured extruded  
polymeric films; knitted fabrics; nonwoven netting  
materials or mesh fabrics; and woven fabric strips.

32. A papermaker's fabric as claimed in claim 22  
wherein said bottom layer of said laminated structure  
comprises at least two distinct sublayers, each of said  
sublayers comprising one of the materials selected from  
5 the group consisting of: staple fiber material; fabric  
woven from fibers or filaments; spun-bond,  
hydroentangled and melt-blown nonwoven fabrics;  
apertured extruded polymeric films; knitted fabrics;  
nonwoven netting materials or mesh fabrics; and woven  
10 fabric strips.

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